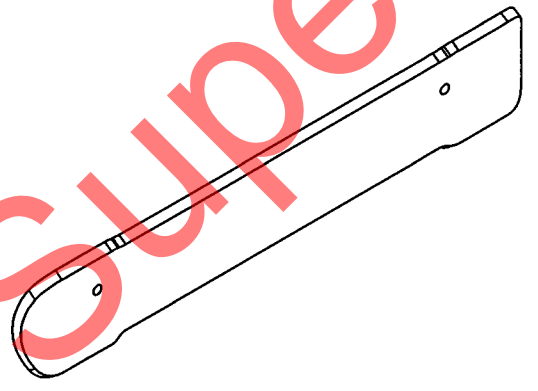
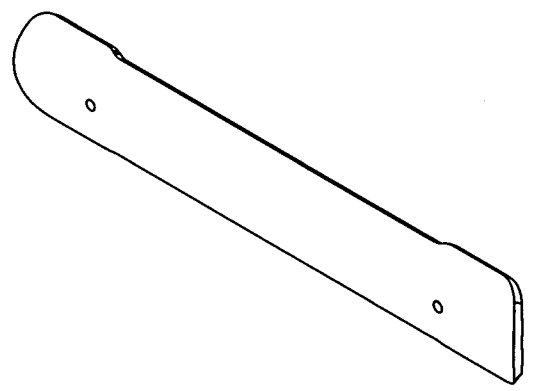


**D5520-1 DOUBLER**  
(BEND DETAIL)

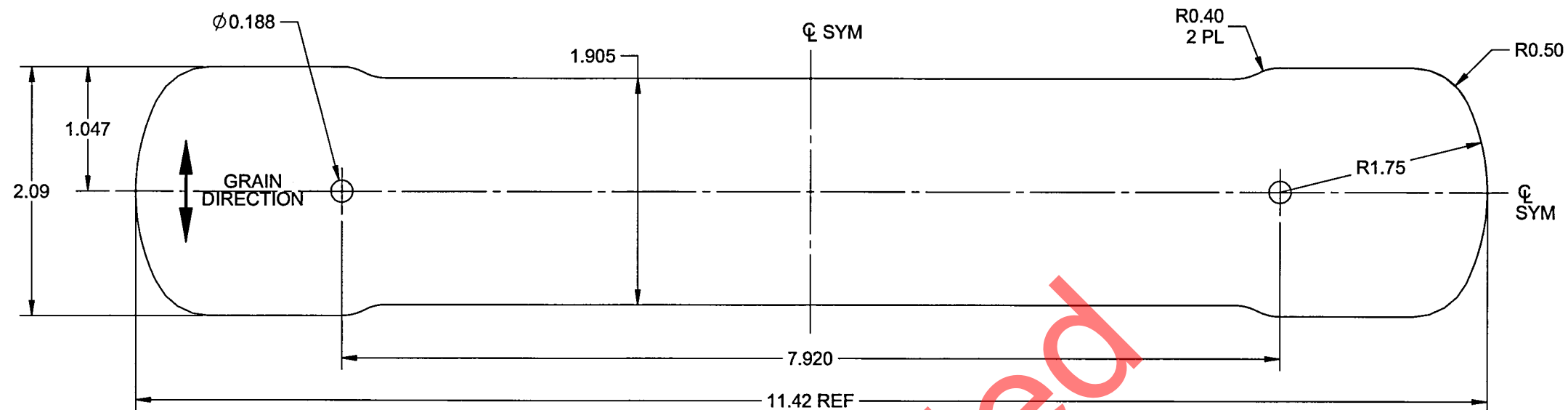


- NOTES:
- 1) MATERIAL: MAKE FROM D5520-1F
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME PER DART QSI 005 4.2
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.40 lbs

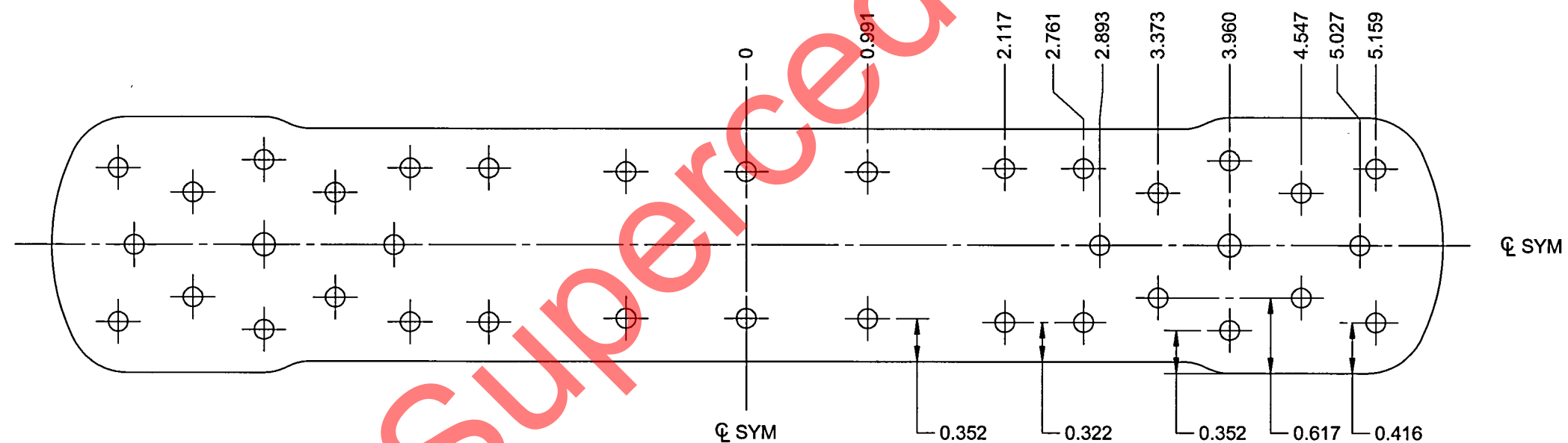
RELEASED  
2017-08-11  
EW17-547

APPROVED

A	NEW ISSUE (NCR17-6303)		ML	17.03.09
REV.	DESCRIPTION		BY	DATE
DESIGN	ML	<b>DART AEROSPACE USA, INC</b> EUGENE, OR		
DRAWN	AJS			
CHECKED	ML	DRAWING NO. <b>D5520</b>		REV. A
MFG. APPR.	DP			SHEET 1 OF 2
APPROVED	WM	TITLE <b>DOUBLER</b>		SCALE
DE APPR.	DS			NTS
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**D5520-1F DOUBLER**  
(FLAT PATTERN)



**D5520-1F DOUBLER**

+ REPRESENTS THE LOCATION OF RIVET HOLES  
TO BE DRILLED ON INSTALLATION  
(HOLES SHOWN AS REFERENCE ONLY)

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR/SHEET, 0.188 THICK  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221 OR QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF. DART SPEC. M6061T6B0.188 OR M6061T6S0.188
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.40 lbs
- 8) DRILL HOLES USING DT10309

RELEASED  
2017-08-11

APPROVED

DESIGN	ML	<b>DART AEROSPACE USA, INC.</b> EUGENE, OR	
DRAWN	AJS		
CHECKED	ML	DRAWING NO.	REV. A
MFG. APPR.	DP	<b>D5520</b>	SHEET 2 OF 2
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	<b>DOUBLER</b>	NTS
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